

June-24-14 1:59:47 PM

121330

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/24/14 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 6/24/14 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14 Dec-24 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D5094; A

100

0.00

100

FLOW WATER JET

0.00

Waterjet

FLOW CNC Waterjet

Memo

1-Cut D5094-1 as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr as required

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

OC

Quality Control

Memo

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Stop *NR2*

14/06/27

Quality Control

Work Order ID 121330

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121330

Page 4

Item ID: D5094-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Post Bracket Assembly
Start Date: 6/24/14 Start Qty: 5.00 *5* Cust Item ID:
Required Date: 6/24/14 Req'd Qty: 5.00 *5* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21 - Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 14-06-27

MF 14-6-26

Picklist Print

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Page 1

Work Order ID: 121330

121330

Parent Item: D5094-041

D5094-041

Parent Item Name: Post Bracket Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 14.04.14 NEW ISSUE DD VERF:JLM IPP
REV:B 14.06.23 as per dwg rev.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA		Purchased		No			sf	721.3700					
-----------	--	-----------	--	----	--	--	----	----------	--	--	--	--	--

M304S18GA

304/316 .050 Sheet

①

DAS
23
9-89

1406-26

Location	Loc Qty	Loc Code
MAT019	709.37	
117188	3	
117766	5	
120604	5	
122325	3	
123155	3	
124572	38	
M126647	31.55	
M128254	91.57	
M128435	123.25	
M128864	126	
M129530	280	
MAT020	12	
124029	2	
M126098	10	

129530

D3622-1

Manufactured No

Each 54.0000

5

D3622-1

Ball Stud

FF 14-06-26

Location	Loc Qty	Loc Code
ST052	54	
114881	34	
119636	20	

5

Picklist Print

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Work Order ID: 121330

121330

Parent Item: D5094-041

D5094-041

Parent Item Name: Post Bracket Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 5.00

Required Qty: 5.00

MS21043-5

Purchased

No

Each

183.0000

5

MS21043-5

FF 14-06-26

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST306

163

116548

88

121584

11

m129499

64

5

NAS1149C0563R

Purchased

No

Each

212.0000

10

NAS1149C0563R

FF 14-06-26

Washer

Location

Loc Qty

Loc Code

ST278

212

m125928

212

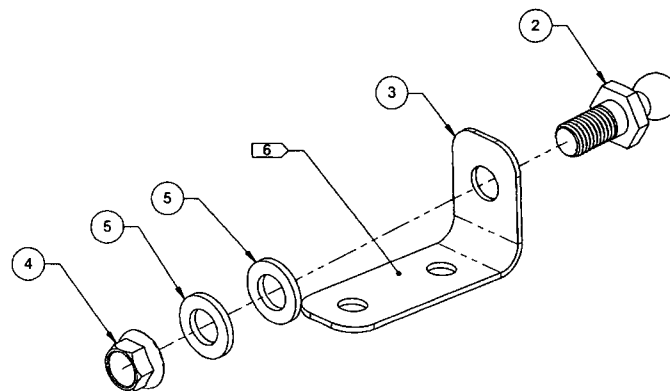
10

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Shop Packet Print

Page 2

ITEM	QTY	P/N	DESCRIPTION
1	X	D5094-041	POST BRACKET ASSEMBLY
2	1	D3622-1	BALL STUD
3	1	D5094-1	BRACKET
4	1	MS21043-5	NUT
5	2	NAS1149C0563R	WASHER



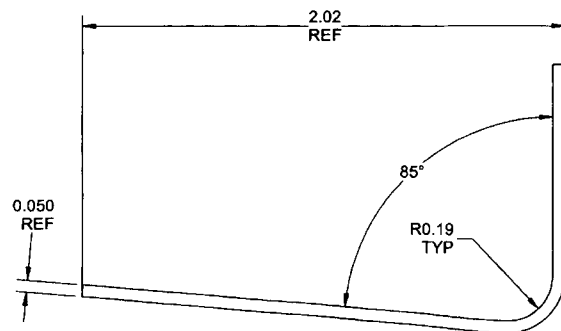
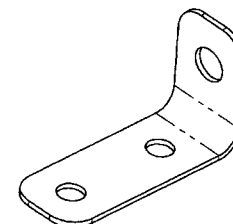
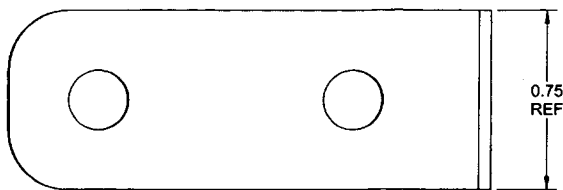
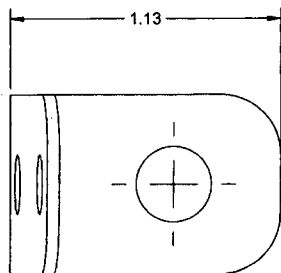
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121330 MJS
140824

D5094-041 POST BRACKET ASSEMBLY

RELEASED
2014-06-20

- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.05 lbs

APPROVED	DESIGN	AK	DART AEROSPACE LTD	
	DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5094	SHEET 1 OF 3
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	POST BRACKET ASSEMBLY	NTS
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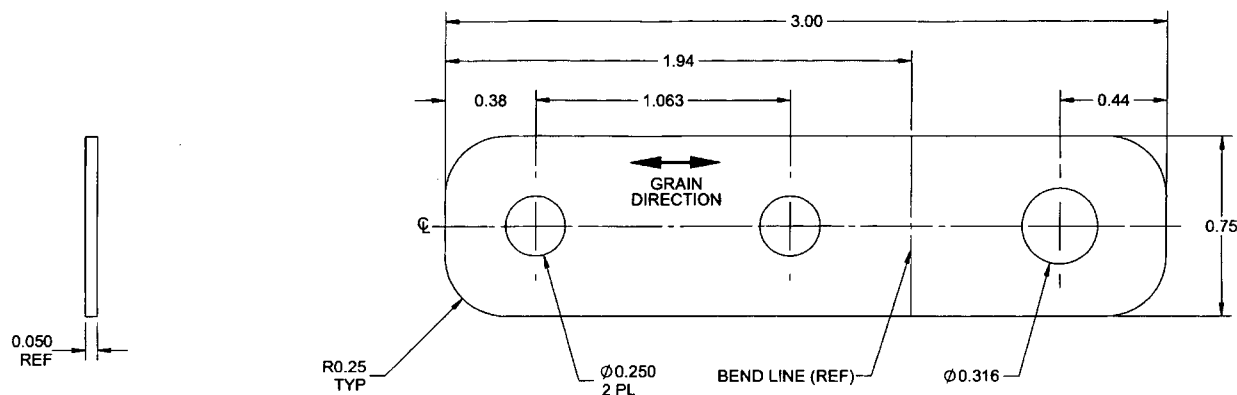
D5094-1 BRACKET

NOTES:

- 1) MATERIAL: MADE FROM D5094-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

RELEASED
2014-06-20

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D5094-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK
MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
OR
AISI 303 SS SHEET, 0.050 THICK
PER MIL-S-5059
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S18GA

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

RELEASED
2014-06-20

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	CHECKED	RF	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5094	SHEET 3 OF 3
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